

Work Order ID 116203

Tuesday, April 08, 2014 11:30:51 AM

116203

Page 1

Item ID: D2012-105 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm (31.06)
 Start Date: 4/8/2014 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/16/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 4-4-14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2012-105	E

100	NC BRAKE	0.00				4x	DAS 28 9-89	MAR 19 2015
100								
Brake NC	Memo	0.00						
Brake NC	Punch to length as per Dwg D2012-105 & template D2012-105T1							

110	Small Fab	0.00				4x	DAS 28 9-89	MAR 19 2015
110								
Small Fab	Memo	0.00						
Small Fab	1-Deburr							

120	QC5- Inspect part completeness to step on W/O	0.00				(4)	DAS 38 9-89	
120								
QC	Memo	0.00						
Quality Control								

MAR 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3 <i>M 124777</i> Memo START TIME: <i>1:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:40</i>	0.00 0.00				<i>4</i>	<i>15-3-23</i>	<i>238</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>			DAS 38 9-89 MAR 23 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>st376</i> Memo	0.00 0.00				<i>4</i>			DAS 27 9-89 MAR 24 2015

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15/3/26 *[Signature]*
mf
15-3-24

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Picklist Print

Tuesday, April 08, 2014 11:30:50 AM

Page 1

Work Order ID: 116203

116203

Parent Item: D2012-105

D2012-105

Parent Item Name: Arm (31.06)

Start Date: 4/8/2014

Required Date: 4/16/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:102.04.03 Added Inspect level 3NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

236.0331

2.6254

12

M304TR0 500W 0.35

**

DAS

MAR 19 2015

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

236.0331

131717

125513

2.5998

m126922

3

m128084

110.4333

m128495

120

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D2012-105 ARM

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
 - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
 - 7) WEIGHT: 0.47 lbs
 - 8) MAKE PER TEMPLATE DT8116
 - 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

E	REFORMAT DWG. ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-080	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	98.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	09.06.04	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	

RELEASED
07/12/14

116203
MUF
14-4-5

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